

Date: Tuesday, 11/21/2006 11:55:31 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKIDTUBE ASSEMBLY
 Job Number : 29587
 Estimate Number : 10022
 P.O. Number : N/A Part Number : D205634011
 This Issue : 11/21/2006 S.O. No. : N/A Drawing Number : N/A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : N/A
 Previous Run : 29586 Material : N/A
 Due Date : 12/4/2006 Qty: 1 Um: Each
 Written By : JA 061121
 Checked & Approved By : JA 061121
 Comment : Est Rev:P 02.08.28 Removed QC5 from Step 5 KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D205-634-011 CHG004

KJ 06.11.27 (1)

2.0 29587A SKID TUBE ASSEMBLY



Comment: Sub-Component SKID TUBE ASSEMBLY

D205-634-041 B 29587A

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 K10003 D205-634-011 Saddle Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 K10003 Saddle Kit B29683

1 D205-634-041 Skidtube Assembly(ref) B29587A

B29587A

Box 101/16

5.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

PU 7/01/16

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RD Date: 07/10/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Site: Tuesday, 11/21/2006 11:55:31 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY

Job Number: 29587

Part Number: D205634011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-011

Location: _____

new

Bar 10/1/16
Bar 10/1/16

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Bar 10/1/16

Job Completion



u 07-01-16

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 11:56:00 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SKID TUBE ASSEMBLY
Job Number	: 29587A		
Estimate Number	: 10023		
P.O. Number	: <i>N/A</i>	Part Number	: D205634041
This Issue	: 11/21/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D2580 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LANDING GEAR	Drawing Revision	: C
Previous Run	: 29586A	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 12/4/2006 Qty: 1 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev: N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ Est Rev. O 06.02.28 Added paperwork EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634 CHG001

N/A

2.0	D25001190	Ext'n -1" Beam Tube 4"
-----	-----------	------------------------



Comment: Qty.: 1.0400 Each(s)/Unit Total : 1.0400 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2500-1-190	Skid Tube Extrusion	<i>B25858 DP 6-11-23</i>

3.0	D2596	205 Web
-----	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2596	205 Web	<i>B29604 DP 6-11-23</i>

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Debur ends

3-Acid etch and Alodine tube per QSI 005 4.1

4-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)

DP 6-11-23
m-k 06/11/23 ①
DP 6-11-23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 11:56:01 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 29587A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5-Open holes to 0.500" as per Dwg D2580 without cutting fluid

6-Countersink holes as per Dwg D2580 without cutting fluid

7-Deburr and blow out all chips from inside of tube

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 M102660

Sikaflex expire date: 07-2-1

Start Time: 6:30pm Date: 6-11-23

Fin Time: 11:10am Date: 6-11-29

DP6-11-23

5.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

> DP6-11-29

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes

Pmc/5b 6-19-04

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 06-12-07

8.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2576-3 Step 029486 BE 06-12-12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 11:56:01 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 29587A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

9.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	D2579	Spacers	229603

BE 06-12-07

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 Step Remove alodine as required.

BE 06-12-07

2-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R Aluminum Rod

M101446

BE 06-12-07

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

JD/DP 06-12-12

4-Drill holes for wearplates using DT 8217. Open holes to .19/.64" adjust stopper not to hit web. Deburr

Pm 06-12-14 ①

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

Pm 06-12-14 ①

6-Drill pilot holes for aft cap using DT 8215. Open holes to #6 Drill bit. Deburr

Pm 06-12-14 ①

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

Pm 06-12-14 ①

8-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R Aluminum Rod

M101446

BE 06-12-12

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

06/12/14 ①

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/12/14 ①

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 11:56:01 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 29587A

Part Number: D205634041

Job Number:



Seq. #: Machine Or Operation: Description :

13.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

M
a.m. / 7d.

06/12/27

(1)

14.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M *06 12 28*

(1)

15.0 D25771 Wearplate Fwd



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-1	Wearplate	<i>B29488</i>

16.0 D25773 Wearplate Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-3	Wearplate	<i>B29326</i>

17.0 D25775 Wearplate, Centre



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-5	Wearplate	<i>B28639</i>

18.0 ALS71032130 Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
44	ALS7-1032-130	Inserts	<i>M102475</i>

a.m. 06/12/28 (1x)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 11:56:01 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 29587A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN960JD10L

Washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 4 AN960JD10L Washer m 102217

20.0

AN34A

Bolt



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number Description Batch
44 AN3-4A Bolt m 102832

21.0

D25941

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

plug

Batch: B28014

22.0

D25943

O-Ring



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

o-ring

Batch: B27168

23.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: B26351

24.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M15205 m-h/a.m 06/12/29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/01/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 11:56:02 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 29587A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: M102217

26.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291

M102672

Sikaflex expire date: 02-07

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

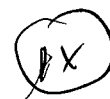
A/R Sikaflex-291

M102672

Sikaflex expire date: 02-07

m.h/a.m

04/12/29



5-Wing Walk as per Dwg D2580 and QSI 005 4.4

M103004

Batch:

a.m

02/01/03



27.0

QC5

INSPECT WORK TO CURRENT STEP



20701.09



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location:

PPP Rev:

N/A

29.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

07/01/16

u 07.01.16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. C SHEET 1 OF 2
DATE 98.08.26		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	

RELEASED
98/09/17 DS

QTY	Part Number	Description
X	D2580-041	SKIDTUBE ASSEMBLY
*	D2500-1	EXTRUSION
1	D2596	205 WEB
1	D2575	AFT CAP
1	D2576 - 3	STEP
20	D2579	CROSS BOLT SPACER
16	D2594-1	PLUG
16	D2594-3	O-RING
1	D2577-1	WEARSHOE
1	D2577-3	WEARSHOE
1	D2577-5	WEARSHOE
44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
46	AN3-4A	BOLT
46	AN960JD10L	WASHER

00.08.28
UP 02.08.28

EFFECTIVE DEOS
98/12/14
DEO 9124
DED 9183

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES *
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (44 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO 29587A

Diagram illustrating the underside of a propeller with grinding locations marked:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576

Diagram illustrating a bolted connection detail. The components and dimensions shown are:

- DRILL PRIOR TO D2575 CAP INSTALLATION (2 PLACES)
- #0.208
- AN3-4A BOLT (1)
- AN960JD10L WASHER (1)
- (2 PLACES)
- D2575 CAP
- SEAL WITH SIKAFLEX-241
- 0.40

Diagram of a circular web with labels:

- Ø2579 SPACER
- WEB (REF)
- Ø130 (REF)
- 4 PLACES

After performance steps:

1. CHA
2. INS
3. WEI
4. C'B

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

37.50
DISTANCE TO AFT END
OF D2596 WEB

3
7

1.750 1.750

#0.508 (TYP.)
(40 PLACES)

REFER TO DETAIL A

8.750
17.375
26.000
34.188

57.313 (REF)
7 EQUAL SPACES
8.188 PITCH

38.0 91.500

190.0
(D2500-1)

Figure 1: Plan view of a horizontal curve. The diagram shows a road layout with a horizontal curve. Key dimensions include: a 1.4m offset at the start of the curve, a 13.4m distance between the hole and the tangent point on the left, a 1.0m distance between the hole and the tangent point on the right, a 32.0m distance between the hole and the tangent point on the right, a 20.0m offset at the end of the curve, a 11.5m offset at the end of the curve, and a #0.640 reinforcement bar. A triangle with the number 4 is shown at the start and end of the curve.

WELD AS PER DETAIL B

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

0.5

1.5

1.5

D

P P P P P P P

REFER TO DETAIL C

D2577-3

D2577-5

D2577-1


8

AN3-4A BOLT (1)
AN96JD10L WASHER (1)
(44 PLACES)

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>
------------------------------	--------------------------------

PART

RELEASED
98/09/17 DS

DESIGN <i>DBH</i>	DRAWN BY <i>CB</i>	 DART AEROSPACE LTD HAMILTON, ONTARIO, CANADA
CHECKED <i>DBH</i>	APPROVED <i>JS</i>	
DRAWING NO. D2580		REV. C SHEET 2 OF 2
TITLE 205 SKIDTUBE ASSEMBLY		SCALE 1:24
DATE 98.08.26		

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 295874

NO. 80

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number A205 634 041 / B 29469 A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/11/29 Qualifier David [Signature]

Date: Friday, 09/02/2007 9:59:35 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D205-635 / D204-635
Job Number	: 30722		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: Z-CUSTOM ECN952/908
This Issue	: 09/02/2007 S.O. No. : N/A	Drawing Number	: UPDATE PAPERWORK
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : OVERHEAD	Drawing Revision	: N/A
Previous Run	: 00015	Material	: N/A
Written By	:	Due Date	: 16/02/2007 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

ADD NEW PAPERWORK TO KITS IN STOCK

TC STC SH96-88, ISSUE 3 / FAA STC SR00563NY

D205-634-011

D205-634-041

D205-634-043

D205-634-045

D204-635-011

D204-635-041

voir papier
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7/4/27 SQ

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

RETURN TO STOCK

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